

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003683**Date Inspected:** 25-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Oregon**CWI Name:** Scot Reed**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge K components**Summary of Items Observed:**

On this date, Caltrans Quality (QA) Assurance Inspector Mr. Danny C. White (B89) was present at Oregon Iron Works (OIW) for the purpose of monitoring fabrication and welding operations of the Hinge K Pipe Beam at the OIW fabrication and welding shop in Clackamas, Oregon.

The QA Inspector performed random observations in the fabrication shop in bay #1 and observed Machine Shop Foreman Mr. Eric Kirkwood was utilizing the 30 foot mill to perform machining operations on the base-plate component marked as a110-4 for this job. Later in the shift the QA Inspector observed Mr. Kirkwood installed a new oil pump into the machine and work on the base plate was delayed for a portion of the shift.

The QA Inspector observed that in bay #3 OIW Welding Operator Mr. Rick Hinkle fabricated stiffener ring marked a112 into the inside of forged tubular marked a111. The QA Inspector observed that Mr. Hinkle placed the ring on blocks which were resting on the fixture and the QA Inspector observed that no welding occurred on this weldment during this shift. The QA Inspector observed that prior to the above mentioned work, Mr. Hinkle had utilized a grinder fitted with a wire wheel and removed oxidized material from the immediate weld joint areas.

Summary of Conversations:

The QA Inspector met with OIW Foreman Mr. Vern Taute and was presented with a package that contained tungsten electrodes. The QA Inspector was informed that the tungsten electrodes utilized during the gas tungsten arc welding (GTAW) stainless steel overlay repair procedure qualification record (PQR) came from this container. The QA Inspector observed the following notations were printed on the package: manufactured by CK Worldwide Inc., 2 percent thorated, 2.4 millimeter diameter electrodes, designation from the American Welding Society (AWS) A5.12.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	White,Danny
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Quality Assurance Inspector

Reviewed By:	Wright,Mark
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QA Reviewer
